


Date: Tuesday, 12/09/2006 11:43:28 AM
User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|---------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | AFT CROSSTUBE |
| Job Number : | 28490 | Part Number : | D2890 |
| Estimate Number : | 10377 | Drawing Number : | D2890 REV B |
| P.O. Number : | N/A | Project Number : | N/A |
| This Issue : | 12/09/2006 | Drawing Revision : | B |
| Prsht Rev. : | NC | Material : | N/A |
| First Issue : | 12/09/2006 | Due Date : | 19/09/2006 |
| Previous Run : | 23964 | Qty: | 2 |
| Written By : |  | | |
| Checked & Approved By : | | | |
| Comment : | Est. D 05.03.21 Removed Bending procedures KJ/JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|---------------------|
| 1.0 | D6008180 | Crosstube extrusion |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

| | | | |
|-----|-----------|---------------------|---------------------|
| Qty | Part # | Description | Batch |
| 1 | D6008-180 | Crosstube extrusion | B22534 DP 6-9-26 DA |

| | | |
|-----|-----------------|----------------------------|
| 2.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
ACID ETCH & ALODINE

25 06 09 26 DA

| | | |
|-----|---------|-----------------|
| 3.0 | BENDING | BENDING MACHINE |
|-----|---------|-----------------|



Comment: BENDING MACHINE

DP 6-9-26 DA

1-Bend D2890 as per Dwg D2890 and Folio FT002

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

See attached

| | | |
|-----|----------------|-------------------------|
| 5.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

Pm 06-10-10 DA

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 06/10/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 12/09/2006 11:43:28 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 28490

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

see 205 896

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)

29 06/10/23

Job Completion



U 06/10/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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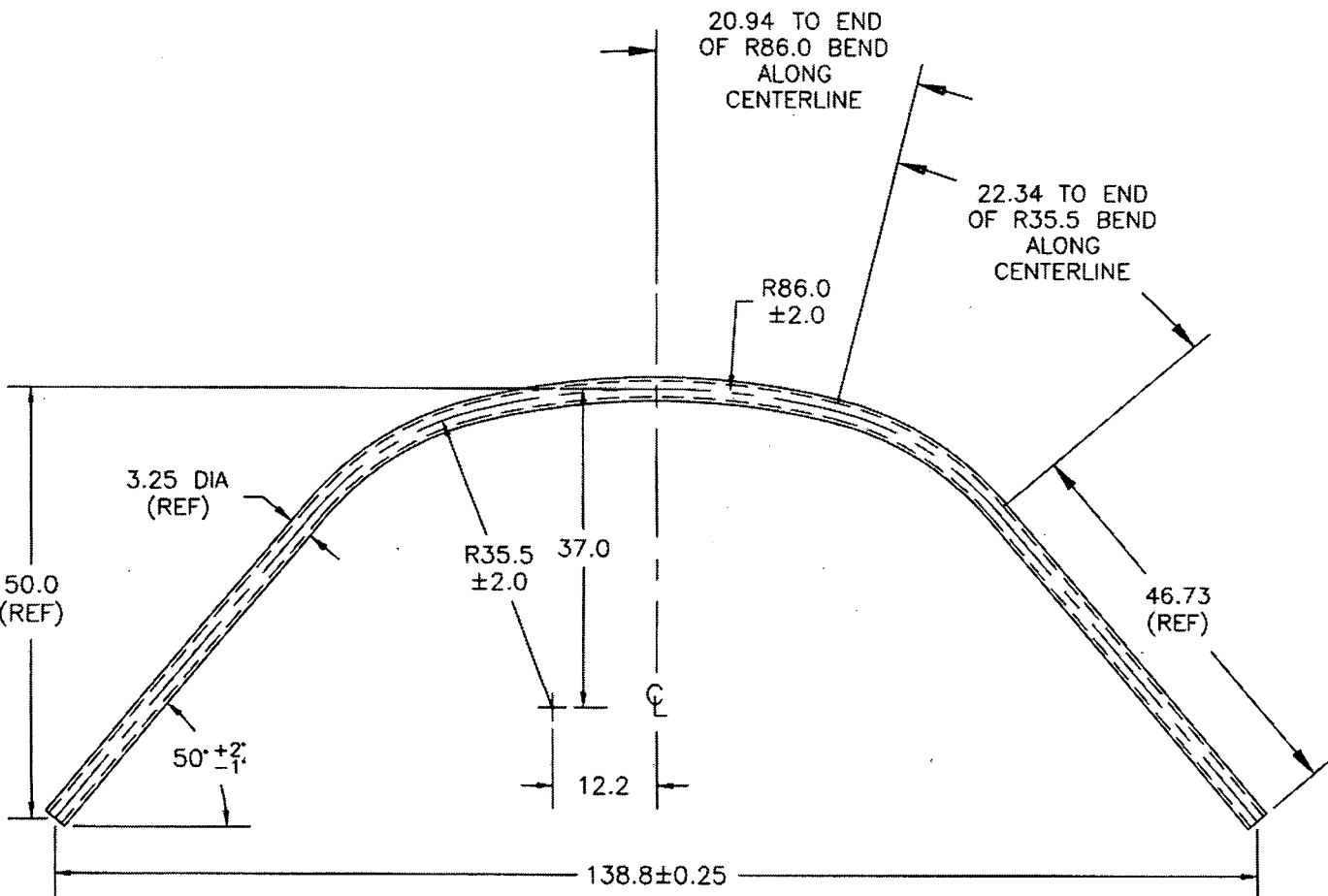
NOTE: Date & initial all entries

REFERENCE ONLY



RELEASED
02.10.28

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|-----------------------------------|-----------------------------|
| 02.10.18 | 99.05.21 | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| # | # | D2890 |
| DATE | TITLE | REV. B |
| 02.10.18 | AFT CROSS TUBE | SHEET 1 OF 1 |
| A | NEW ISSUE | SCALE |
| B | ADD TANGENT LENGTHS; CHANGE NOTES | 1:20 |



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (Ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

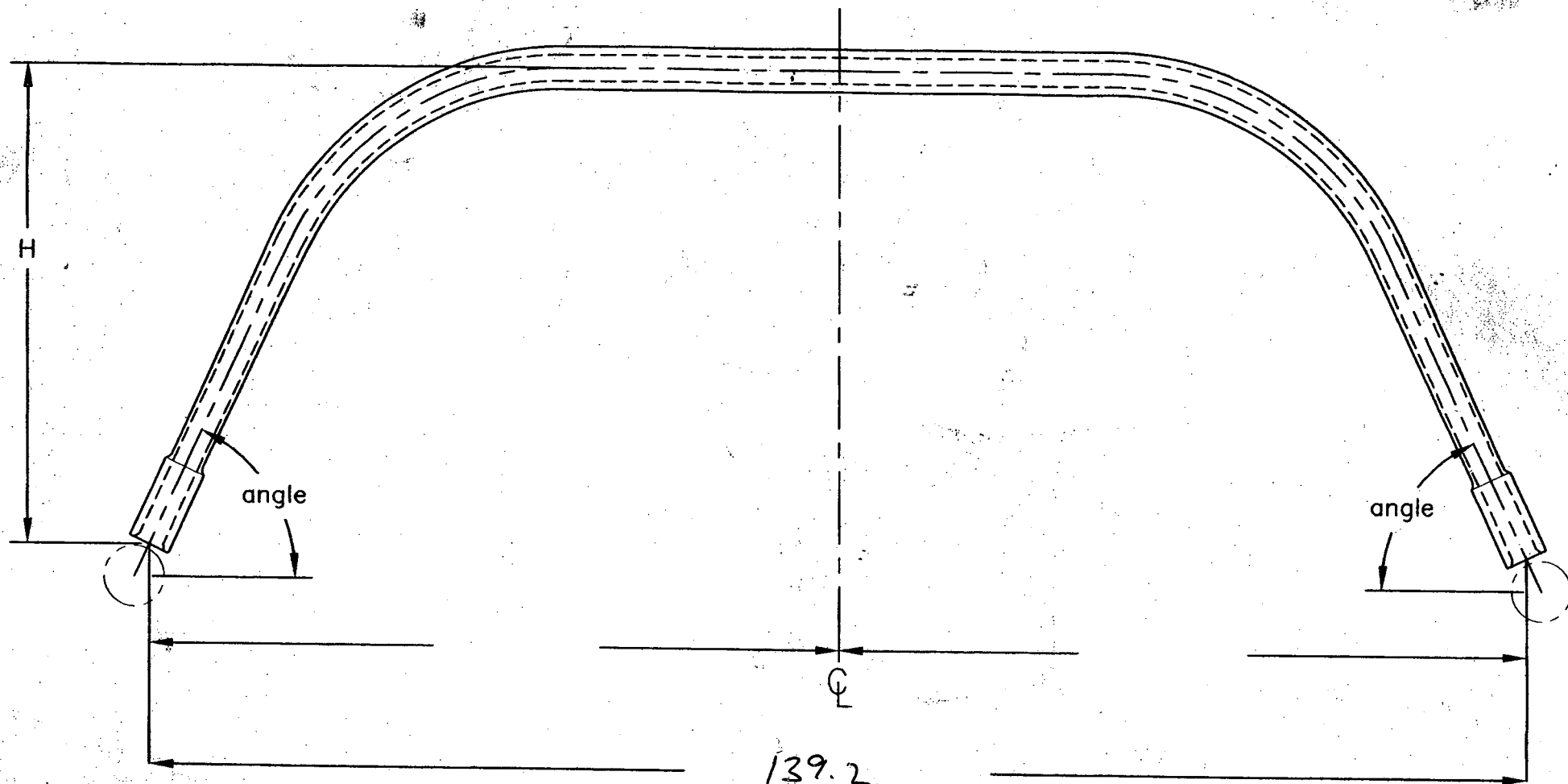
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



DATE: 06/10/02

DESCRIPTION: 2890

BATCH NO: 28490 tube A.

DRAWING: 02890

H: N/A

1/2 SPAN: N/A

TOTAL SPAN: 138.8 + .25

ANGLE: _____

[Signature]
06-10-02

